

Ship March 9.

Work Order ID 141154

141154

Page 1

January 29, 2016 8:57:26 AM

Item ID: D206-642-311BL Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Skidtube LH (Ael Blue)
Start Date: 1/21/2016 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 3/9/2016 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: SU Date: 6 0 1 2 9 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
IIN-D206-642	Q								

100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D206-642-311 CHG008								

MCS 16-03-01
MAR 09 2016

110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

MAR 01 2016
DAS 6 9-89

120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

MAR 09 2016
DAS 27 9-89
DAS 28 9-89

B141152

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐	☐	Pressure/Forced ☐	☐	Temperature/Cure ☐	☐
Design ☐	☐	Operator ☐	☐	Bending ☐	☐	Set-up ☐	☐
Doc/Data ☐	☐	Offset/Setup ☐	☐	Centre Not Concentric ☐	☐	BOM/Route ☐	☐
Equip/Tooling ☐	☐	Supplier ☐	☐	Cracks ☐	☐	Broken/Damage/Defect ☐	☐
Handling/Pre ☐	☐	Training ☐	☐	Crimp/Kink/Ripple/Wave ☐	☐	Inspection Incomplete/Unqualified ☐	☐
Material ☐	☐	Use for Testing ☐	☐	Cuffs ☐	☐	Contamination ☐	☐
Internal Transport ☐	☐	Poor Information ☐	☐	Crushing ☐	☐	Countersink ☐	☐
Tribal Knowledge ☐	☐	Rushing ☐	☐	Heat Treat ☐	☐	Cut Too Short ☐	☐
LOA ☐	☐	Product Improvement ☐	☐	Wave/Twist in Tube ☐	☐	Instructions Incomplete/Unclear ☐	☐
Substation ☐	☐	Process Improvement ☐	☐	Marks/Chatter ☐	☐	Drill Holes ☐	☐
Past Expiry Date ☐	☐	Manufacturing Process ☐	☐	OTHER : ☐			
Misidentified ☐	☐	Past Due ☐	☐				

Work Order ID 141154***141154***

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January 29, 2016 8:57:26 AM

Item ID: D206-642-311BL

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube LH (Ael Blue)

Start Date: 1/21/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/9/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-311								
	Location: _____								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

1x
DAS 27 MAR 09 2016
28 9:59

MLS MAR 09 2016

MLS MAR 09 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY					
Environment ☐		No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐		Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐		Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐		Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐		Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐		Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐		Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐		Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐		Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐		Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐		Manufacturing Process ☐	OTHER : _____					
Misidentified ☐		Past Due ☐						

Picklist Print

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Page 1

Work Order ID: 141154

141154

Parent Item: D206-642-311BL

***D206-642-311RI ***

Parent Item Name: Skidtube LH (Ael Blue)

Start Date: 1/21/2016

Required Date: 3/9/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J05.10.11Added D3429-1 per CHG004KJ/CP/JLM/EC
IPP Rev:K 07-12-04 ECN 1080p DD verified by:ec
IPP Rev:L 08-09-29 as per DS19421 DD verified by:EC IPP Rev:M
as per REV.N DD 10.04.19 verified by:EC IPP Rev:N 14.04.25
ECN14-520 DD verf:JLM IPP REV:O 15.10.09 ADDED
BL DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D206-642-341BL		Manufactured	No				Each	2.0000	1				
*D206-642-341RI *									**	B 141152			DAS 28 9-89
Replacement Skidtube (Fits LH or RH)													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG				2					
					140301			1					
					140305			1					
D206-648-013BL		Manufactured	No				Each	0.0000	1				DAS 6 9-89
*D206-648-013RI *									**	142336			DAS 28 9-89
Ground Handling Wheel Modification													
D2932-1BL		Manufactured	No			110	Each	2.0000	1				DAS 28 9-89
*D2932-1RI *									**	141036			DAS 28 9-89
Saddle LH Out, 206													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST392				2					
					138656			2					
D2933-1BL		Manufactured	No			110	Each	1.0000	1				DAS 6 9-89
*D2933-1RI *									**	140961			DAS 28 9-89
Saddle LH In, 206													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST389				1					
					139883			1					

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Work Order ID: 141154

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Parent Item: D206-642-311BL

***D206-642-311RI ***

Parent Item Name: Skidtube LH (Ael Blue)

Start Date: 1/21/2016

Required Date: 3/9/2016

Start Qty: 1.00

Required Qty: 1.00

D2938-1BL Manufactured No

110 Each 1.0000 1

***D2938-1RI ***

Saddle LH Out, 206

**

140964 DAS 6 9-89 DAS 28 9-89

Location Loc Qty Loc Code

ST390 1

139952 1

D2939-1BL Manufactured No

110 Each 3.0000 1

***D2939-1RI ***

Saddle LH In, 206

**

140997 DAS 6 9-89 DAS 28 9-89 MAR 07 2016

Location Loc Qty Loc Code

ST391 3

138653 3

AN3-41A Purchased No

110 Each 466.0000 8

AN3-41A

Bolt

**

DAS 6 9-89 DAS 28 9-89

Location Loc Qty Loc Code

FG 20

122416 20

over003 314

123355 314

ST347 132

123355 132

D2652 Manufactured No

110 Each 439.0000 16

D2652

Bushing

**

DAS 6 9-89 DAS 28 9-89

Location Loc Qty Loc Code

FG 45

31985 45

ST009 394

136228 387

136792 7

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Work Order ID: 141154

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Parent Item: D206-642-311BL

***D206-642-311BL ***

Parent Item Name: Skidtube LH (Ael Blue)

Start Date: 1/21/2016

Required Date: 3/9/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

110

Each

2,544.000

8

8

MS21042L3

Nut

**

DAS
6
9-89

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

CCK007

2000

m134039

2000

FP001

163

m133790

163

GA

195

m133790

195

ST304

186

m133790

186

NAS1149D0363J

Purchased

No

110

Each

1,858.000

8

8

NAS1149D0363J

Washer

**

DAS
6
9-89

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

84

m130799

84

ST260a

1000

m134055

1000

ST263

774

m133790

274

m133932

500

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Work Order ID: 141154

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH (Ael Blue)

141154

***D206-642-311BL ***

Start Date: 1/21/2016

Required Date: 3/9/2016

Start Qty: 1.00

Required Qty: 1.00

AN5-10A

Purchased

No

110

Each

322.0000

4

4

AN5-10A

Bolt

**

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

51

122800

51

over003

200

m133769

50

m134039

150

ST338

71

m133483

71

DAS
6
9-89

DAS
28
9-89

AN5-11A

Purchased

No

110

Each

109.0000

4

4

AN5-11A

BOLT

**

DAS
27
9-89

Location

Loc Qty

Loc Code

over003

50

M134039

50

ST338

59

M133077

9

M133234

50

DAS
6
9-89

DAS
28
9-89

MAR 11 2016

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Work Order ID: 141154

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH (Ael Blue)

141154

***D206-642-311BL ***

Start Date: 1/21/2016

Required Date: 3/9/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0563.I

Purchased

No

110

Each

1,410.000

8

NAS1149D0563.I

Washer

**

DAS

6
9-89

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

53

m125807

53

ST260a

900

m133769

400

m133990

500

ST263

354

m133363

154

m133938

200

ST269

103

m128257

103

AN4-6A

Purchased

No

110

Each

1,185.000

12

12

AN4-6A

BOLT

**

DAS

6
9-89

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

CA

143

M128403

43

M130851

100

over03

1000

M133790

1000

ST345

42

M133316

18

M133363

24

MAR 01 2016

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Work Order ID: 141154

141154

Parent Item: D206-642-311BL

***D206-642-311RI ***

Parent Item Name: Skidtube LH (Ael Blue)

Start Date: 1/21/2016

Required Date: 3/9/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

110

Each

5,435.000

25

25

NAS1149D0463.J

WASHER

**

DAS
6
9-89

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA	397
M129390	41
M132035	356
ST260a	2000
M134039	2000
ST263	1689
M134039	1689
ST269	1349
M130799	361
M132317	100
M132677	888

25

MS21042L4

Purchased

No

110

Each

3,356.000

12

12

MS21042L 4

Locknut

**

DAS
6
9-89

MAR 01 2016

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001	41
m133363	41
GA	26
m127813	26
ST007	1500
m134055	1500
ST303	1692
m133769	1692
ST305	97
m130922	97

12

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Page 7

Work Order ID: 141154

141154

Parent Item: D206-642-311BL

***D206-642-311RI ***

Parent Item Name: Skidtube LH (Ael Blue)

Start Date: 1/21/2016

Required Date: 3/9/2016

Start Qty: 1.00

Required Qty: 1.00

D3407-043

Manufactured No

110 Each

12.0000

1

D3407-043

Tow Ring

**

140316

Location

Loc Qty

Loc Code

st530

12

136685

10

136686

2

DAS
6
9-89

DAS
28
9-89

BLUE

D3456-1

Manufactured No

110 Each

125.0000

1

D3456-1

Washer

**

Location

Loc Qty

Loc Code

FG

7

25701

7

ST038

118

136922

43

140756

75

DAS
6
9-89

DAS
28
9-89

D3457-1

Manufactured No

110 Each

66.0000

2

D3457-1

Washer

**

Location

Loc Qty

Loc Code

FG

10

32409

10

ST037

8

127393

8

ST038

4

136442

4

ST038A

44

138904

44

DAS
6
9-89

DAS
28
9-89

MAR 01 2016

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Work Order ID: 141154

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH (Ael Blue)

141154

***D206-642-311BL ***

Start Date: 1/21/2016

Required Date: 3/9/2016

Start Qty: 1.00

Required Qty: 1.00

MS21043-4

Purchased

No

110

Each

1,034.000

0

1

MS21043-4

Nut

**

DAS

6

9-89

DAS

28

9-89

Location

Loc Qty

Loc Code

FG 40

104603 40

GA 262

m132803 262

ST302 10

m133316 10

ST32 722

m133769 722

DAS
27
9-89

AN4C5A

Purchased

No

110

Each

80.0000

0

1

AN4C5A

Bolt

**

DAS

6

9-89

DAS

28

9-89

Location

Loc Qty

Loc Code

OVER002 50

m133990 50

ST345 30

m132857 10

m133135 20

DAS
27
9-89

NAS1149C0463R

Purchased

No

110

Each

212.0000

0

1

NAS1149C0463R

Washer

**

DAS

6

9-89

DAS

28

9-89

Location

Loc Qty

Loc Code

FP001 72

m127306 72

ST271 140

m128401 40

m133077 100

DAS
27
9-89

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Work Order ID: 141154

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH (Ael Blue)

141154

***D206-642-311RI ***

Start Date: 1/21/2016

Required Date: 3/9/2016

Start Qty: 1.00

Required Qty: 1.00

D3413-1

Manufactured No

110 Each

21.0000

D3413-1

O-Ring

DAS
27
9-89

Location

Loc Qty

Loc Code

st530

21

136462

21

**

14155280

DAS
28
9-89

BLUE

D2712

Manufactured No

110 Each

433.0000

10

D2712

Set Screw

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

55

29962

55

ST009

278

102226

12

135950

242

89929

10

93686

14

ST012a

100

140532

100

D2934

Manufactured No

110 Each

42.0000

2

D2934

Saddle Spacer

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

6

31929

6

ST014

36

136146

36

**

DAS
28
9-89

DAS
28
9-89

MAR 01 2016

Picklist Print

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Work Order ID: 141154

141154

Parent Item: D206-642-311BL

***D206-642-311BI ***

Parent Item Name: Skidtube LH (Ael Blue)

Start Date: 1/21/2016

Required Date: 3/9/2016

Start Qty: 1.00

Required Qty: 1.00

D2935

Manufactured No

110

Each

30.0000

2

2

D2935

Saddle Spacer

Location

Loc Qty

Loc Code

FG

6

31793

6

ST014

24

136244

24

DAS

6

9-89

DAS

28

9-89

DAS
27
9-89

MAR 01 2016

Work Order ID 141154

January 29, 2016 8:57:26 AM

141154

Page 1

Ship March 9.

Item ID: D206-642-311BL

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Skidtube LH (Ael Blue)

Start Date: 1/21/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/9/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

SH

Date: 6 0 1 2 9

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN-D206-642

Q

DAS
6

100

Document Control

0.00

DAS
6

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D206-642-311 CHG008

MCS

MAR 01 2016

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

MAR 01 2016

DAS
6
-06

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

4.5 206 L/L-1/L-3/L-4/407 LOW & HIGH GEAR SKIDTUBES

ITEM	QTY -311	QTY -312	QTY -313	QTY -314	QTY -341	QTY -357	QTY -349	QTY -351	QTY -013	PART NUMBER	DESCRIPTION
	X									D206-642-311	SKIDTUBE INSTALLATION, LH
		X								D206-642-312	SKIDTUBE INSTALLATION, RH
			X							D206-642-313	SKIDTUBE INSTALLATION, LH
				X						D206-642-314	SKIDTUBE INSTALLATION, RH
	(1)	1			X					D206-642-341	SKIDTUBE
						X				D206-642-357	WEARSHOE KIT (REPLACES -347)
							X			D206-642-349	RUN-ON LANDING WEARPLATE KIT
			1	1				X		D206-642-351	SKIDTUBE
	(1)	1	1	1					X	D206-648-013	GROUND HANDLING KIT
1					1					D2650-5	SKIDTUBE ASSEMBLY
1								1		D4361-041	SKIDTUBE ASSEMBLY
2A					14			4		D2651-1	* PLUG ⁽¹⁾
2B					14			4		D2651-3	* O-RING ⁽¹⁾
3					1			1		D2646	* AFT CAP ⁽¹⁾
4					2			2		MS27039-1-08	* SCREW ⁽¹⁾
5					2			2		NAS1149D0332J	* WASHER ⁽¹⁾ (OR AN960JD10L)
6	(1)		1							D2932-1	SADDLE, FWD OUT, LH
6		1		1						D2932-2	SADDLE, FWD OUT, RH
7	(1)		1							D2933-1	SADDLE, FWD IN, LH
7		1		1						D2933-2	SADDLE, FWD IN, RH
8	(1)		1							D2938-1	SADDLE, AFT OUT, LH
8		1		1						D2938-2	SADDLE, AFT OUT, RH
9	(1)		1							D2939-1	SADDLE, AFT IN, LH
9		1		1						D2939-2	SADDLE, AFT IN, RH
10	(8)	8	8	8						AN3-41A	BOLT
11	(16)	16	16	16						D2652	BUSHING
12A	(8)	8	8	8						MS21042-3	NUT (OR MS21042L3)
12B	(8)	8	8	8						NAS1149D0363J	WASHER (OR AN960JD10)
13	(4)	4	4	4						AN5-10A (OR AN5-11A)	* BOLT ⁽²⁾
14	(4)	4	4	4						AN5-11A (OR AN5-12A)	* BOLT ⁽²⁾
15	(8)	8	8	8						NAS1149D0563J	WASHER (OR AN960JD516)
16	(12)	12	12	12						AN4-6A	BOLT
17	(24)	24	24	24						NAS1149D0463J	WASHER (OR AN960JD416)
18	(12)	12	12	12						MS21042-4	NUT (OR MS21042L4)
20A					6	6				D3537-1	WEARPAD (REPLACES D2648-3)
21A					1	1				D3537-3	WEARPAD (REPLACES D3429-1)
22A					1	1				D4956-11	WEARSHOE (REPLACES D3535-11 + D3536-11)
23A					1	1				D4956-23	WEARSHOE (REPLACES D3535-23 + D3536-23)
24A					1	1				D4956-35	WEARSHOE (REPLACES D3535-35 + D3536-35)
26A					54	54				MS27039C1-08	SCREW
26B					54	54				NAS1149C0332R	WASHER (OR AN960C10L)
26C					54					ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	(1)	1	1	1						D3407-043	TOW RING ASSEMBLY (REPLACES D2968-043)
32A	(1)	1	1	1						D3456-1	WASHER
32B	(2)	2	2	2						D3457-1	WASHER
33	(1)	1	1	1						MS21043-4	NUT
34	(1)	1	1	1						AN4C5A	BOLT
35	(1)	1	1	1						NAS1149C0463R	WASHER (OR AN960C416)
36	(1)	1	1	1						D3413-1	RING (REPLACES D2655)
37	(10)	10	10	10						D2712	SET-SCREW
38	(2)	2	2	2						D2934	SADDLE SPACER
39	(2)	2	2	2						D2935	SADDLE SPACER
40									2	D3414-041	GHW LUG (REPLACES D2659)
41									4	AN3C37A	BOLT
42									8	D2652	BUSHING
43									4	MS21043-3	NUT
44									4	NAS1149C0363R	WASHER (OR AN960C10)

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